FORM PTO-1390 (Modified) (REV 11-2000) U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE

TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371

ATTORNEY'S DOCKET NUMBER	U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR
144-220	10/070506

INTERNATIONAL APPLICATION NO.	INTERNATIONAL FILING DATE	PRIORITY DATE CLAIMED
PCT/FR99/02119	September 7, 1999	September 7, 1999

TITLE OF INVENTION

TRANSFER PRINTING INSTALLATION, IN PARTICULAR BY GILDING

APPLICANT(S) FOR DO/EO/US

Guy, Marcel, Charles , Claude Breger and Alain, Charles, Marcel, Jacques Breger

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☒ This is an express request to begin national examination procedures (35 U.S.C. 371(f)). The submission must include itens (5), (6), (9) and (24) indicated below.
4. ☒ The US has been elected by the expiration of 19 months from the priority date (Article 31).
5. ☒ A copy of the International Application as filed (35 U.S.C. 371 (c) (2))
   a. ☐ is attached hereto (required only if not communicated by the International Bureau).
   b. ☒ has been communicated by the International Bureau.
   c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US).
6. ☒ An English language translation of the International Application as filed (35 U.S.C. 371(c)(2)).
   a. ☒ is attached hereto.
   b. ☐ has been previously submitted under 35 U.S.C. 154(d)(4).
7. ☒ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371 (c)(3))
   a. ☐ are attached hereto (required only if not communicated by the International Bureau).
   b. ☐ have been communicated by the International Bureau.
   c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
   d. ☒ have not been made and will not be made.
8. ☐ An English language translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☐ An oath or declaration of the inventor(s) (35 U.S.C. 371 (c)(4)).
10. ☐ An English language translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371 (c)(5)).
11. ☒ A copy of the International Preliminary Examination Report (PCT/IPEA/409).
12. ☒ A copy of the International Search Report (PCT/ISA/210).

Items 13 to 20 below concern document(s) or information included:

13. ☒ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
14. ☐ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.
15. ☒ A **FIRST** preliminary amendment.
16. ☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.
17. ☐ A substitute specification.
18. ☐ A change of power of attorney and/or address letter.
19. ☐ A computer-readable form of the sequence listing in accordance with PCT Rule 13ter.2 and 35 U.S.C. 1.821 - 1.825.
20. ☐ A second copy of the published international application under 35 U.S.C. 154(d)(4).
21. ☐ A second copy of the English language translation of the international application under 35 U.S.C. 154(d)(4).
22. ☒ Certificate of Mailing by Express Mail
23. ☒ Other items or information:

Courtesy Copy of Publication PCT/FR99/02119
Unexecuted Declaration and Power of Attorney
U.S. Express Mail No. EL 813789703 US

U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR	INTERNATIONAL APPLICATION NO.	ATTORNEY'S DOCKET NUMBER
10/070506	PCT/FR99/02119	144-220

24: The following fees are submitted:.

BASIC NATIONAL FEE (37 CFR 1.492 (a) (1) - (5)) :

		CALCULATIONS PTO USE ONLY
☒	Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO and International Search Report not prepared by the EPO or JPO **$1040.00**	
☐	International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search Report prepared by the EPO or JPO **$890.00**	
☐	International preliminary examination fee (37 CFR 1.482) not paid to USPTO but international search fee (37 CFR 1.445(a)(2)) paid to USPTO **$740.00**	
☐	International preliminary examination fee (37 CFR 1.482) paid to USPTO but all claims did not satisfy provisions of PCT Article 33(1)-(4) **$710.00**	
☐	International preliminary examination fee (37 CFR 1.482) paid to USPTO and all claims satisfied provisions of PCT Article 33(1)-(4) **$100.00**	
	ENTER APPROPRIATE BASIC FEE AMOUNT =	**$1,040.00**
	Surcharge of **$130.00** for furnishing the oath or declaration later than ☐ 20 ☐ 30 months from the earliest claimed priority date (37 CFR 1.492 (e)).	**$0.00**

CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE	
Total claims	12 - 20 =	0	x $18.00	**$0.00**
Independent claims	1 - 3 =	0	x $84.00	**$0.00**
Multiple Dependent Claims **(check if applicable)**			☐	**$0.00**

TOTAL OF ABOVE CALCULATIONS =	**$1,040.00**
☒ Applicant claims small entity status. See 37 CFR 1.27). The fees indicated above are reduced by 1/2.	**$520.00**
SUBTOTAL =	**$520.00**
Processing fee of **$130.00** for furnishing the English translation later than ☐ 20 ☐ 30 months from the earliest claimed priority date (37 CFR 1.492 (f)). +	**$0.00**
TOTAL NATIONAL FEE =	**$520.00**
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31) **(check if applicable).** ☐	**$0.00**
TOTAL FEES ENCLOSED =	**$520.00**
Amount to be: refunded	$
charged	$

a. ☒ A check in the amount of **$520.00** to cover the above fees is enclosed.

b. ☐ Please charge my Deposit Account No. _____ in the amount of _____ to cover the above fees. A duplicate copy of this sheet is enclosed.

c. ☒ The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. **50-0573** A duplicate copy of this sheet is enclosed.

d. ☐ Fees are to be charged to a credit card. **WARNING:** Information on this form may become public. **Credit card information should not be included on this form.** Provide credit card information and authorization on PTO-2038.

NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.

SEND ALL CORRESPONDENCE TO:

Robert E. Cannuscio
Drinker Biddle & Reath LLP
One Logan Square
18th and Cherry Streets
Philadelphia, Pennsylvania 19103-6996

23973
PATENT TRADEMARK OFFICE

SIGNATURE

ROBERT E. CANNUSCIO
NAME

36,469
REGISTRATION NUMBER

March 7, 2002
DATE

PATENT

Attorney Docket No.: 144-220

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re:	Patent application of Guy, Marcel, Charles, Claude Breger et al.	:	
Serial No.:	10/070506	:	International Serial No. PCT/FR99/02119
Filed:	March 7, 2002	:	International Filing Date: 7 September 1999
For:	Transfer Printing Installation, In Particular By Gilding	:	

FEE FOR ADDITIONAL CLAIMS

Commissioner for Patents
Washington, D.C. 20231

Transmitted herewith is an amendment in the above-identified patent application.

The fee for claims (37 CFR 1.16(b)-(d)) has been calculated as shown below:

CERTIFICATE OF MAILING
UNDER 37 C.F.R. 1.8(a)

I hereby certify that this paper, along with any paper referred to as being attached or enclosed, is being deposited with the United States Postal Service on the date indicated below, with sufficient postage, as first class mail, in an envelope addressed to: Commissioner for Patents, Washington, D.C. 20231.

BY Tesia Richardson

DATE: April 29, 2002

PHIP/313700v1

	(Col. 1)		(Col. 2)	(Col. 3)	Large Entity	Small Entity	
	Claims Remaining After Amendment		Highest No. Previously Paid For	Present Extra	Rate	Rate	Additional Fee
Total	24	Minus	20	= 4	x 18 =	x 9 =	$ 72
Independent	3	Minus	3	= 0	x 84 =	x 42 =	$ --
First Presentation of Multiple Dependent Claim					+280 =	+ 140 =	$ --
						TOTAL	$ 72

Payment of Fee for Claims:

A check in the amount of **$72** is enclosed. The Commissioner is hereby authorized to charge any additional fees for claims which may be required, or to credit any overpayment, to the above Deposit Account 50-0573. This paper is submitted in duplicate.

Respectfully submitted,

GUY BREGER et al.

BY: _____

ROBERT E. CANNUSCIO
Registration No. 36,469
DRINKER BIDDLE & REATH LLP
One Logan Square
18th & Cherry Streets
Philadelphia, PA 19103-6996
Tel: (215) 988-3303
Fax: (215) 988-2757
Attorney for Applicants

#3

PATENT

Attorney Docket No.: 144-220

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re:	Patent application of Guy, Marcel, Charles, Claude Breger et al.	:	
Serial No.:	10/070506	:	International Serial No. PCT/FR99/02119
Filed:	March 7, 2002	:	International Filing Date: 7 September 1999
For:	Transfer Printing Installation, In Particular By Gilding	:	

SUPPLEMENTAL PRELIMINARY AMENDMENT

Commissioner for Patents
Box PCT
Washington, D.C. 20231

Sir:

Prior to examination in the United States Patent and Trademark Office, please make the following amendments in the above-identified application in order to place it in condition for examination.

A Fee of Additional Claims Form accompanies this amendment to cover the cost for the additional claims.

CERTIFICATE OF MAILING
UNDER 37 C.F.R. 1.8(a)

I hereby certify that this paper, along with any paper referred to as being attached or enclosed, is being deposited with the United States Postal Service on the date indicated below, with sufficient postage, as first class mail, in an envelope addressed to: Commissioner for Patents, Washington, D.C. 20231.

BY Lisa Richardson

DATE: April 29, 2002

AMENDMENT

Please amend the application as follows, without prejudice.

In the Claims:

Please add the following new claims.

13. A system of transfer printing, in particular gilding, a motif lifted from a transfer film by a die, which is to be affixed as a marker on a continuous, receiving strip that has been pre-printed by a gravure process, wherein at the instant of the transfer, the positioning of the pre-printed receiving strip underneath the tool and the strip of transfer film is synchronized, the system comprising:

a. a means for driving the transfer film;

b. a means for driving and positioning the receiving strip and immobilizing it during the transfer;

c. a transfer station; and

d. a control means for driving:

the drive means so that the drive means of the transfer film feeds the film forward by the step corresponding to the motifs, in readiness for the transfer,

the means for driving and positioning the receiving strip, which feeds this strip forward by the step corresponding to the printed motif, the extra accumulated pre-printed strip being formed into a loop,

the transfer means of the transfer station where the transfer means comprise a heating plane operated by a jack,

the cutting means incorporating a cutter, and

the control means immobilizing the transfer film and the receiving strip during the transfer and cutting process.

14. System as claimed in claim 13 wherein the means for driving the films and the means for driving the receiving strip both operate step by step, or one is operated step by step and the other continuously, or both are operated continuously.

15. System as claimed in claim 13, wherein there are several means for driving films in parallel, the means transferring several motifs to the receiving strip simultaneously.

16. A product made using the system claimed in claim 13, wherein the strip has polychromatic motifs, with or without metal, holographic motifs and zones intended to permit binary recordings, the material for this purpose being lifted from the transfer strip.

17. A product made using the system in claim 13, wherein the strip has antennas.

18. A product made using the system of claim 13, wherein the strip has a printed circuit.

19. System of transfer printing, in particular gilding, a motif lifted from a transfer film by a die, which is to be affixed as a marker on a continuous, receiving strip that has been pre-

printed by a gravure process, wherein at the instant of the transfer, the positioning of the pre-printed receiving strip underneath the tool and the strip of transfer film is synchronized, the system comprising:

a. a means for driving the transfer film;

b. a means for driving and positioning the receiving strip and immobilizing it during the transfer;

c. a transfer station; and

d. a control means for driving:

the drive means so that the drive means of the transfer film feeds the film forward by the step corresponding to the motifs in readiness for the transfer,

the means for driving and positioning the receiving strip, which feeds this strip forward by the step corresponding to the printed motif, and

the transfer means of the transfer station comprising at least one transfer element mounted on a rotary element, and the drive means of the film and that of the receiving strip are controlled so as to drive the film and the receiving strip at the same speed as the peripheral speed of the transfer element during the transfer process, the transfer means including:

a first detector assigned to the strip in order to detect the step of the product and supply a signal by means of a control managing the forward feed of the strip provided with pre-printed markers intended to be read by the detection means,

a second detector assigned to the film to detect the motif of the film and supply a signal to the control means managing the drive means of the film,

a tensioning system for the transfer film and/or films comprising a double jack system coupled with the intake and outlet cylinder.

20. System as claimed in claim 19, wherein the means for driving the films and the means for driving the receiving strip both operate step by step, or one is operated step by step and the other continuously, or both are operated continuously.

21. System as claimed in claim 19, wherein there are several means for driving films in parallel, the means transferring several motifs to the receiving strip simultaneously.

22. A product made using the system claimed in claim 19, wherein the strip has polychromatic motifs, with or without metal, holographic motifs and zones intended to permit binary recordings, the material for this purpose being lifted from the transfer strip.

23. A product made using the system in claim 19, wherein the strip has antennas.

24. A product made using the system of claim 19, wherein the strip has a printed circuit.

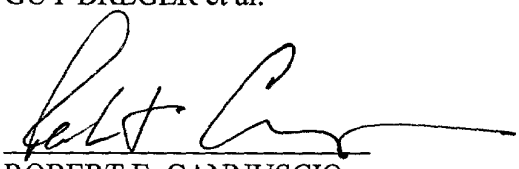
REMARKS

Claims 1-12 are pending. Claims 13-24 have been added to the application and are supported by the specification. No new matter has been introduced.

Applicants look forward to an early action on the merits.

Respectfully Submitted,

GUY BREGER et al.

BY 

ROBERT E. CANNUSCIO
Registration No. 36,469
Drinker Biddle & Reath LLP
One Logan Square
18th and Cherry Streets
Philadelphia, PA 19103-6996
(215) 988-3303
(215) 988-2757 – Fax
Attorney For The Applicants

PATENT

Attorney Docket No.: 144-220

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re:	Patent application of Guy, Marcel, Charles, Claude Breger et al.	:	
Serial No.:	Not Yet Assigned	:	International Serial No. PCT/FR99/02119
Filed:	March 7, 2002	:	International Filing Date: 7 September 1999
For:	Transfer Printing Installation, In Particular By Gilding	:	

PRELIMINARY AMENDMENT

Commissioner for Patents
Box PCT
Washington, D.C. 20231

Sir:

Prior to examination in the United States Patent and Trademark Office, please make the following amendments in the above-identified application in order to place it in condition for examination.

CERTIFICATE OF MAILING
UNDER 37 C.F.R. 1.10

EXPRESS MAIL Mailing Label Number: EL 813789703 US
Date of Deposit: March 7, 2002

I hereby certify that this correspondence, along with any paper referred to as being attached or enclosed, and/or fee, is being deposited with the United States Postal Service, "EXPRESS MAIL–POST OFFICE TO ADDRESSEE" service under 37 C.F.R. 1.10, on the date indicated above, and addressed to: Commissioner for Patents, Washington, D.C. 20231.

Signature of person mailing page

Therese McKinley
Type or print name of person

AMENDMENT

Please amend the application as follows, without prejudice.

In the Specification:

Insert the following on page 1, line 4.

--Background of the Invention--

Insert the following on Page 2, line 16:

--Summary of the Invention--

Insert the following on Page 5, line 1:

--Brief Description of the Drawings--

Insert the following on Page 5, line 20:

--Detailed Description of the Invention--

In the Abstract:

Please add the following Abstract to the application.

--A system is disclosed for transfer printing of a motif lifted from a transfer film to a receiving strip to form a product. The system synchronises the transfer film and the receiving strip at a transfer station at the point of transfer. The system includes a film driver, a strip driver and a controller for controlling the strip and film drivers.--

In the Claims:

(Clean copy of amended claims)

Please amend the claims as follows:

1. (Amended) System of transfer printing, in particular gilding, a motif lifted from a transfer film by a die, which is to be affixed on a receiving strip to form a product, the transfer film and the receiving strip being synchronised at the transfer station at the instant of transfer, comprising:

means for driving the transfer film,

means for driving the receiving strip,

a transfer station having a transfer means,

control means controlling the film drive means, the strip drive means and the transfer means, whereby the film drive means feeds the film forward by a first step corresponding to the motif to be transferred and the strip drive means feeds said strip forward by a second step of the product in readiness for each transfer.

2. (Amended) System as claimed in claim 1, wherein the transfer means includes a transfer element which is activated by a jack, the control means immobilising the film and the strip during the time the transfer is being operated.

3. (Amended) System as claimed in claim 1, wherein the transfer means comprises at least one transfer element mounted on a rotary element; and wherein the film drive means and the strip drive means are controlled so as to drive the film and the receiving strip at substantially the same speed as the peripheral speed of the transfer element during the time the transfer is being operated.

4. (Amended) System as claimed in claim 1, further comprising a first detector assigned to the strip to detect the second step of the product and supply a signal to the control means for managing the forward movement of the strip; and wherein the strip includes pre-printed markers designed to be read by the first detector.

5. (Amended) System as claimed in claim 1, further comprising a second detector assigned to the film to detect the motif of the film and supply a signal to the control means for managing the film drive means.

6. (Amended) System as claimed in claim 1, wherein the film drive means and the strip drive means are controlled in a manner selected from a group consisting of both operated step by step, one operated step by step and the other continuously, and both operated continuously.

7. (Amended) System as claimed in claim 1, wherein there are a plurality of film drive means, disposed in parallel, for driving a plurality of films so that several motifs can be transferred to the receiving strip substantially simultaneously.

8. (Amended) System as claimed in claim 1, wherein the transfer means includes a transfer cylinder, which prints successive motifs with an offset in order to reduce overlapping thicknesses when the strip is stored after the transfer.

9. (Amended) System as claimed in claim 8, wherein the transfer cylinder includes transfer elements that are distributed around a cylinder with a circular section in an offset arrangement following a line corresponding to the intersection of the cylinder by an inclined plane.

10. (Amended) System as claimed in claim 8, wherein the transfer cylinder includes transfer elements are designed to apply to the strip polychromatic motifs, holographic motifs and zones intended to permit binary recordings, the material for this purpose being lifted from the transfer strip.

11. (Amended) System as claimed in claim 9, wherein the transfer elements are designed to apply to the strip an antenna of various shapes and dimensions in order to optimise the effect of a magneto-restrictive coating with a thickness of approximately 25 to 900 Angström, designed to resonate in an alternating electromagnetic field generated at a selected frequency between approximately 73 and 530 Hz and which will cause no resonance when deactivated.

12. (Amended) System as claimed in claim 9, wherein the transfer elements are designed to enable the transfer of various shapes and dimensions of printed circuits having insulating and conductive layers, at least one chip in order to transfer onto the strip an antenna capable of recording, calculating and emitting for providing an intelligent marker.

REMARKS

Claims 1-12 are pending in the application. The claims have been amended to corrected to conform to United States practice. Minor editorial changes to the claims have been made. Sub-headings have been added to the description. No new matter has been introduced.

Applicants look forward to an early action on the merits.

Respectfully Submitted,

GUY BREGER et al.

BY

ROBERT E. CANNUSCIO
Registration No. 36,469
Drinker Biddle & Reath LLP
One Logan Square
18th and Cherry Streets
Philadelphia, PA 19103-6996
(215) 988-3303
(215) 988-2757 – Fax
Attorney For The Applicants

Appendix - Marked Up Version of Claims

1.[°)] (Amended) System of transfer printing, in particular gilding, a motif lifted from a transfer film by a die, which is to be affixed on a receiving strip to form a product, [-] the transfer film and the receiving strip being synchronised at the transfer station at the instant of transfer, [characterised in that it comprises] comprising:

[-] [a] means for driving [(3)] the transfer film[(1)],

[-] [a] means for driving [(5)] the receiving strip[(2)],

[-] a transfer station [(4)] having a transfer means,

[-] [a] control means [(7)] controlling the film drive means, the strip drive means and the transfer means, whereby the film drive means [(3, 31, 32) of the film (1)] feeds the film [(1)] forward by a first step [(L1)] corresponding to the motif to be transferred and the strip drive means [(5) of the receiving strip (2)] feeds said strip [(2)] forward by [the] a second step [(L2)] of the product [(22, 23)] in readiness for each transfer[, and the transfer means (41, 42) of the transfer station (4)].

2.[°)] (Amended) System as claimed in claim 1, [characterised in that] wherein the transfer means includes a transfer element [(41) at the transfer station (4)] which is activated by a jack [(42)], the control means [(7)] immobilising the film [(1)] and the strip [(2)] during the time the transfer is being operated.

3.[°)] (Amended) System as claimed in claim 1, [characterised in that] wherein the transfer means [(4A)] comprises at least one transfer element [(411A, 412A)] mounted on a rotary element [(41A)]; and wherein the film drive means [for driving (3A) the film (1A)] and the strip drive means [that of the receiving strip (2A)] are controlled [(7A)] so as to drive the film [(1A)] and the receiving strip [(2A)] at substantially the same speed as the peripheral speed of the transfer element [(41A)] during the time the transfer is being operated.

4.[°)] (Amended) System as claimed in claim 1, [characterised by] further comprising a first detector [(71, 71A)] assigned to the strip [(2, 2A)] to detect the second step [(L2)] of the product and supply a signal [(S)] to the control means [(7A)] for managing the forward

movement of the strip [(2A)]; and wherein the strip [(2, 2A) has] includes pre-printed markers [(23, 23A)] designed to be read by the first detector [detection means (71, 71A)].

5.[°)] (Amended) System as claimed in claim 1, [characterised in that] further comprising [it has] a second detector [(72C)] assigned to the film [(1C)] to detect the motif [(14C)] of the film [(1C)] and supply a signal [(S2)] to the control means [(7C)] for managing the film drive means [of the film (1C)].

6.[°)] (Amended) System as claimed in claim 1, [characterised in that] wherein the film drive means [for driving the film (1)] and the strip drive means [for driving the receiving strip (2)] are controlled in a manner selected from a group consisting of both [operate] operated step by step, [or] one [is] operated step by step and the other continuously, [or] and both [are] operated continuously.

7.[°)] (Amended) System as claimed in claim 1, [characterised by] wherein there are a plurality of film drive [several] means, disposed in parallel, for driving a plurality of films [(1B, 1'B)] so that several motifs can be transferred to the receiving strip [(2B)] substantially simultaneously.

8.[°)] (Amended) System as claimed in claim 1, [characterised in that] wherein the transfer means includes a transfer cylinder, [the transfer element (41F) is a cylinder,] which prints [the] successive motifs with an offset in order to reduce overlapping thicknesses when the strip is stored [reeled or the sheets cut from the strip are stacked] after the transfer.

9.[°)] (Amended) System as claimed in claim 8, [characterised in that] wherein the transfer cylinder includes [the] transfer elements [(411E, 412E) of the transfer cylinder (41F)] that are distributed around a cylinder with a circular section in an offset arrangement following a line corresponding to the intersection of the cylinder by an inclined plane [(ellipse)].

10.[°)] (Amended) System as claimed in claim 8, [characterised in that] wherein the transfer cylinder includes transfer elements [(411F) and (412F)] are designed to apply to the strip [(2A)]

polychromatic motifs [with or without metal], holographic motifs and zones intended to permit binary recordings, the material for this purpose being lifted from the transfer strip [(1) or (1A)].

11.[°)] (Amended) System as claimed in claim 9, [characterised in that] wherein the transfer elements [(411F) and (412F)] are designed to apply to the strip [(2E)] an antenna of various shapes and dimensions [incorporating amplifiers for example,] in order to optimise the effect of a magneto-restrictive coating with a thickness of approximately 25 to 900 Angström, designed to resonate in an alternating electromagnetic field generated at a selected frequency between approximately 73 and 530 Hz and which will cause no resonance when deactivated.

12.[°)] (Amended) System as claimed in claim 9, [characterised in that] wherein the transfer elements [(411E) and 412E)] are designed to enable the transfer of various shapes and dimensions of printed circuits having insulating and conductive layers, at least one chip [one or more chips] in order to transfer onto [a] the strip [(2D)] an antenna capable of recording, calculating and emitting [in order to provide] for providing an intelligent marker.

SYSTEM FOR TRANSFER PRINTING, IN PARTICULAR GILDING

The present invention relates to a system of transfer printing, in particular for gilding, a motif lifted from a transfer film by a die, which is to be affixed on a receiving strip to form a product, the transfer film and the receiving strip being synchronised at the transfer station at the instant of transfer.

Such systems or the methods of transfer corresponding to such a system are known. They consist of hot transfer printing systems operating on the conventional principle of what is known as gold leaf gilding.

A gilding iron M is used for this process (figure 1A), the bottom face of which bears the imprint to be applied in the form of a gilded imprint onto a strip B of paper, for example. To this end, a transfer film F, is pressed against the strip B and some parts of it, corresponding to the relief of the gilding iron M, are detached and remain adhered to the strip B.

Traditionally, the transfer film F was an extremely thin sheet of gold, which was applied hot with a pressing element, such as a gilding iron (M), against the paper or leather substrate (strip B). The outline or mark of the gilding iron remains adhered to the strip B and the parts of the film F which are not adhered are simply removed by peeling them off.

This hot gilding process is used only for bookbinding, covering and similar activities involving luxury work or for restoring antique objects.

In many cases, the gold film is replaced by a system comprising a base film C1 provided with a dividing layer C2 which adheres to the layer to be transferred C3, C4, which may be metallic or coloured. The layer to be transferred C3, C4 may be a coloured layer C3 and a metallic layer C4 with an adhesive layer C5.

When pressed onto the transfer film F, the gilding iron M is itself in contact with the strip or more generally the substrate B to which print is to be applied. When the gilding iron M is pressed onto the transfer film F, already in contact with the strip, or more generally the substrate B, the compressed parts of the film F

adhere to the latter B (fig. 1B). Then, as explained, the iron M is removed and only the imprint formed by the layers C2, C3, C4, C5 adhere to the strip B, whilst the parts F, G that were not compressed by the iron M are torn away by shearing and separated from the imprint E, remaining adhered to the base C1 (Fig. 1C). This compression is effected against a support or pressing element P.

This known technique is applied discontinuously by a continuous leaf by leaf printing process, whereby a receiving strip and a gilding film (transfer film) are fed between two cylinders, one of which is a contact cylinder and the other a heated cylinder bearing one or more dies. The two cylinders rotate in opposite directions and, as the strip and film are fed through, the die prints onto the strip. On leaving, the transfer film together with the unused part of the transfer product is reeled.

The disadvantage of this system is that it consumes a lot of transfer film, i.e. a length of transfer film equal to that of the receiving strip, given that the surface of the transfer film actually used to produce the motif represents only a very small fraction of the total surface area of the transfer film.

The objective of the present invention is to remedy this drawback and a means is proposed whereby hot gilding operations or operations of a similar nature can be performed by transfer in such a way that the consumption of transfer film is the same as that of the gilding or sheet-by-sheet transfer whilst being faster and enabling this method to be used for other applications such as holography and anti-theft security features.

To this end, the invention relates to a transfer printing system corresponding to the type defined above, characterised in that it comprises

- a means for driving the transfer film,
- a means for driving the receiving strip,
- a transfer station,
- a control means which controls the drive means, whereby the drive means of the film feeds the film forward by a step corresponding to the motif to be transferred and the drive means of the receiving strip feeds said strip forward by the step of the product in readiness for each transfer, as well as

the transfer means of the transfer station.

The advantage of the system proposed by the invention is that it consumes only exactly the length (or surface) of transfer film needed to produce the motif on the receiving strip. The control system of the drive means enables this system to be adapted directly online to an upstream printing system or a pre-printed strip, unwound from a reel, to be processed. With the same degree of efficiency, the same output and the same degree of economy, the system enables extremely different motifs or several motifs to be printed by transfer.

By virtue of another characteristic of the invention, the transfer element at the transfer station is activated by a jack and the control means immobilises the film and the strip during the time in which the transfer is being operated.

In an alternative solution, the transfer means comprises at least one transfer element mounted on a rotary element and the means for driving the film and that of the receiving strip are controlled so as to drive the film and the receiving strip at the same speed as the peripheral speed of the transfer element during the time the transfer is being operated.

The choice as to which of these solutions to use will depend in particular on how much space is available and the type of motif to be transferred.

In either case, several transfer films and several transfer elements may be juxtaposed on a level with the transfer station to enable transfer films of different types to be used.

As a result of another feature, a first detector is assigned to the strip to detect the step of the product and supply a signal to the control means managing the forward movement of the strip; and the strip has pre-printed markers designed to be read by the detection means.

The marker is pre-printed on the receiving strip. It defines the position of the products to be made (labels, packaging), which will be cut to the requisite dimensions on leaving the system.

This pre-printed marker may be combined with a pre-printed image, in which case the motif obtained by transfer must be positioned exactly relative to the pre-printed image; the marker may also be nothing more than a marker enabling the

forward feed of the strip in the transfer station to be controlled.

If the transfer involves not just a motif which is merely transferred from the blank transfer film but also includes a motif applied to the transfer film beforehand, the transfer film and in particular the pre-printed motif which it carries with it to the transfer station must be positioned absolutely accurately and, this being the case, the invention offers another advantage in that a second detector is provided to detect the motif of the film and supply a signal to the control means managing the drive means of the film.

Depending on the system requirements, the products to be made and the nature of the transfer films and receiving strips, the means for driving the film and that for driving the receiving strip may both operate step by step; alternatively, one may be operated step-by-step and the other continuously or both may be operated continuously, at variable speeds depending on the stage of the operating cycle.

By virtue of another advantageous feature, the system has several means for driving films so that several motifs can be transferred to the receiving strip simultaneously or in succession. This might be necessary for the reasons already explained above, due to the nature of the motifs to be transferred. It might also be of use if the motifs to be transferred are distributed across the receiving strip at points some distance from one another in order to avoid too large dimensions and, as a result, too high an inertia as would occur if a single transfer element were being controlled by a single jack.

As a result of another advantageous feature, the transfer element is a cylinder, which prints the successive motifs with an offset in order to reduce overlapping thicknesses when the strip is reeled or the sheets cut from the strip are stacked after the transfer.

This offset between successive transfer elements is useful in situations where the printed motif adds extra thickness.

To this end, in a particularly advantageous manner, the transfer elements of the transfer cylinder are distributed around a cylinder with a circular section in an offset arrangement following a line corresponding to the intersection of the cylinder by an inclined plane (ellipse).

The present invention will be described in more detail below with reference to the appended drawings, in which:

- figures 1A, 1B, 1C show the three successive steps of a hot gilding operation known from the prior art, applied to a film in place of a gold film.

- figure 2 is a schematic view of a first embodiment of a transfer printing system as proposed by the invention,

- figure 3 is a schematic view of a second embodiment of a transfer printing system as proposed by the invention,

- figure 4 is a schematic side view of the system, illustrating the operating principle illustrated in figure 3,

- figure 5 is a plan view of the system illustrated in figure 4,

- figure 6 is a schematic view of a transfer printing system similar to that of figure 4 but for several transfer films, side by side,

- figure 7 is a side view of another embodiment of a transfer printing system,

- figures 8, 9 illustrate three examples of receiving strips with pre-printed motifs with security elements,

- figure 10 is a perspective view of a transfer cylinder.

As may be seen from figure 2, the invention relates to a system of transfer printing, in particular for hot press gilding, for printing a motif which is lifted from a transfer film 1 and affixed to a receiving strip 2. This system incorporates a means 3 for feeding and driving the film 1 and a means 5 for driving and feeding the receiving strip 2.

The drive means 3, consisting of a supply reel 31 and a take-up reel 32, feeds the transfer film 1 into a transfer station 4 consisting of a die 41 controlled by a jack 42 and supported against a support surface at the transfer station, not illustrated, to support the receiving strip during the transfer process.

The drive means 3 for the transfer film 1 feeds the film forward, transversely to the feed direction of the strip 2, each time by a length L1

substantially corresponding to the length of the motif to be transferred. Once transferred, this motif 21 leaves a marking 11 on the transfer film 1, as may be seen in the part of the film downstream of the station 4; the feed direction of the transfer film 1 is indicated by arrow A.

The feed and drive means 5 of the receiving strip 2 has a supply cylinder, not illustrated, located in the right-hand part of figure 2. Unwound in the direction of arrow B, the strip 2 is driven by two intake cylinders 51, 52 downstream of the transfer station 4; these cylinders are driven by a stepper motor upstream of the station 4, for example, by two cylinders 53, 54 continuously feeding the receiving strip 4; these cylinders 53, 54 are followed by another pair of cylinders 55, 56, after which a loop 57 is formed to compensate for the step-by-step action on a level with the transfer station 4 as the product arrives at constant speed.

At the end of the line, the products 22 are cut by a cutter 6, schematically illustrated by a blade. These products may be labels, packaging or similar products.

The system is managed by a control means 7 linked to the drive means 3 of the transfer film 1, the drive means 5 of the receiving strip 2, the transfer station 4 and the cutter 6 by lines, not shown by reference numbers, linked to the different means and motors, which are also not illustrated.

This control means 7 receives operating data as well as the signal S issued by a sensor 71, which detects markers 23 carried by the strip 2. These markers 22 define the position of the motifs 21 and products 22 on the receiving strip 2.

Depending on the signal S from the sensor 71, the control means 7 causes the receiving strip 2 to move forward by a distance of the step L2 of the product 22 on a level with the transfer station 4 and immobilises the part of the strip 2 located at this point. At the same time, the control means 7 causes the transfer film 1 to be moved forward in the transfer station 4 by a step L1. The film 1 and strip 2 are then immobilised whilst the die 41 prints the motif onto the strip 2 and is then lifted off again.

After this lifting action, the film 1 is no longer in contact with the strip 2. The drive means may then move the transfer film 1 forward by a step L1 and the receiving strip 2 by a step L2.

The step L2 of the strip 2 depends on what products are being made. These products 22 are joined, as may be seen on a level with the cutter 6.

The step of the transfer film 1 is limited to the length L1 of the motif to be transferred. In the simplest of cases, the film 1 crosses the strip 2 at a right angle on a level with the station 4. This layout is basic but there are other variants. In practice, to transfer a motif which fits inside a rectangular frame with the same elongation as the motif 21, it is more practical to opt for the layout illustrated and juxtapose the markings 11 on the film as close together as possible; if the motif is inscribed within a parallelogram, it may be more practical to incline the arrangement at a corresponding angle, again with a view to reducing the gap between the markings 11 to a minimum; this situation might occur in the case of a word in italic type, for example.

The receiving strip 2 is a strip of printed paper, for example. The print may be applied by gravure printing groups in an online rotary process on the system illustrated in figure 3. Consequently and in order to make allowance for the fact that the strip 2 is fed at constant speed, the loop 57 is formed upstream of the cylinders 53, generally speaking between the last printing group and the transfer printing unit.

The operations which take place at the transfer station 4 each time the strip 2 is halted are as follows:

- the transfer film 1 is fed forwards by a step L1,
- the transfer element 41 is lowered,
- the pre-printed receiving strip 2 is positioned,
- the transfer element 41 is pressed down onto the transfer film 1 in order to apply it against the receiving strip 2,
- the transfer element 41 is raised again,
- the transferred part is detached and separated from the transfer film 1 and forms the motif,
- the receiving strip 2 with a motif thus transferred is fed forwards,
- the strip 2 is cut
- the transfer film is reeled back onto the reel 32 by the length of a step L1.

This sequence of operations is repeated in synchronisation with the printing groups downstream of the transfer printing station and the cutting of the receiving strip downstream of this station.

It should be pointed out that this system may be applied in general terms to the transfer of a motif from the transfer film 1 to the receiving strip 2 timed to any step chosen for the receiving strip 2 and the material of the transfer film 1 may be economised to the maximum by reducing the step L1 to the strict minimum.

In particular, these operations may be used to produce gilding, in which case the transfer film will have a structure similar to that described in relation to figure 1A, i.e. it will consist of a base of polyester, for example, a dividing layer, a coloured layer, a metallic layer and finally an adhesive layer. Viewed in this order, this structure corresponds to the disposition of the transfer film illustrated in figure 2. The base film is located on the top, on the side of the transfer element 41, whilst the adhesive layer is located on the side of the receiving strip.

Depending on the nature of the transfer film, the transfer element 41, operated by pressure, may be cold or hot. If operated hot, the element is fitted with an integrated heating means, not illustrated, for example an electrical resistor, operating under the control of a temperature regulator in order to keep the transfer element at the requisite transfer temperature without the risk of spoiling the transfer motif or receiving strip 2 by too hot a gilding iron.

The receiving strip 2 may be pre-printed, as mentioned above.

The motif to be transferred is applied to the transfer element 41 and the transfer film is uniform, carrying no particular print.

Positioning of the motif on the receiving strip is regulated by the relative positioning of the receiving strip and the transfer element, taking account of the different operations to be performed upstream and downstream of the transfer.

Figure 3 illustrates another approach to operating a transfer printing system. This system operates in the parallel direction, i.e. the receiving strip 2 and the transfer film 1 circulate in the same direction. Figure 3 provides a schematic illustration of this system, shown in more detail in figures 4 and 5.

The same reference numbers as those used for figure 2 will be used for the description of figures 3, 4, and 5 to denote the same elements of the system. These references are suffixed with the letter A.

Turning to figure 3, the system comprises a supply roller 31A and a take-up roller 32A which feed the transfer film 1A into the transfer station 4A. This station 4A comprises a cylinder 41A provided with transfer elements 411A, 412A co-operating with a contact cylinder 42A. The receiving strip 2A and the film 1A pass through the gap between the cylinders 41A, 42A.

The two transfer elements 411A, 412A on the transfer cylinder 41A are plates.

The direction of rotation of the cylinder 41A and that of the contact cylinder 42A are indicated by arrows C, D.

The receiving strip 2A is fed continuously (arrows B) whilst the transfer film 1A is fed at the same speed as the strip 2A at the instant of transfer, when one of the transfer elements 411A, 412A applies the film 1A against the receiving strip 2A as it rotates. Outside of this synchronised phase, however, the transfer film 1 is fed forward only by a step corresponding to the length of the film to be used to make the transfer. This step essentially corresponds to the height of the motif to be transferred.

The receiving strip 2A has markers 23A to position the strip at the point at which it must be whenever the motif 21A is transferred. The marking 11A of the motif appears on the film 1A downstream of the station 4A. This arrangement with parallel feeding of the film 1A and the strip 2A makes the transfer station 4A more compact and allows several transfer films of different types to be placed alongside one another in order to apply several transfers to the same receiving strip simultaneously. The motif 21A may be of the type which appears and is automatically visible and a non-visible or coded motif constituting an anti-theft security measure. Since the two motifs are different in nature, they will be applied to and supported on a different base.

This parallel layout also enables a different number of motifs to be transferred to a same product, for example a legible motif 21A, such as a mark, and

several invisible or coded motifs 24A such as an anti-theft security feature, repeated along the edge or two edges of the product; in this case, the film 1A will be located between two other films, not illustrated in figure 3.

These motifs 24A are shown in a simple format and merely by way of illustration in figure 3 whereas the transfer elements and the transfer film for producing them are not illustrated but are disposed across the width of the transfer film 1A.

Figures 4 and 5 provide a more detailed illustration of the system shown in figure 3.

Here, in addition to the means already described above, the system has, upstream of the transfer cylinder 41A, a guide cylinder 33A with a contact foot 34A, controlled so as to retain the transfer film 1A downstream of the foot 34A once the film has been fed forward by a sufficient length to allow a transfer to be performed as contact is made between the transfer cylinder 41A and the contact cylinder 42A rotating in synchronisation.

After this, there are two intake drive cylinders 35A, 36A like those described in the system of figure 2, which draw the transfer film 1A along at variable speed depending on the operating phase (forward by a step and synchronous movement with the strip 2A for the transfer process).

This variable speed feed action is compensated by a sliding system 37A formed by two cylinders 371A, 372A with, in the gap in between, a cylinder 373A loaded with a weight to form a variable length loop. Finally, the take-up cylinder 32A receives the film 1A downstream of the transfer station 4A.

For reasons of space and access, the contact cylinder 42A is in a raised position and closer to the film 1A in the transfer station 4A than along the rest of the route travelled by the strip 2A upstream and downstream of the cylinder 42A; the deflection is produced by two auxiliary cylinders 421A, 422A.

The shoe 34A is controlled by the central control system 7A, for example, which is illustrated schematically and to a limited extent only; the detector 71A for the markers 23A on the strip 2A is shown in figure 5. Figure 5 also shows the motifs 25A printed on the strip 2A before it receives the transfer or transfers 21A.

As may be seen from the plan view of figure 5, the transfer film 1A occupies only a fraction of the width of the strip 2A. Other transfer films with different materials may be placed alongside this first transfer film 1A to produce other transfers.

Figure 5 also shows the drive motor 413A of the cylinder 41A and that 351A of the cylinder 35A.

A similar situation is also schematically illustrated in figure 6, which shows the part of the system limited to the transfer station 4B and the upstream and downstream means. As above, the reference numbers used in figure 6 are the same as those above suffixed with the letter B. The two supply cylinders are shown by references 31B, 31'B and the take-up cylinders by references 32B, 32'B. The other parts of the system are identical or similar to those illustrated in the previous drawings and will not be described in detail.

Figure 7 illustrates another embodiment of the system for transferring pre-printed motifs onto the transfer film. The same reference numbers will be used in this part of the description, suffixed with the letter C, to denote means that are the same or similar to those described above, the description of which will only be given partly.

This system is used for transferring "pre-printed" motifs onto the transfer film 1C; these may be simple motifs but in particular are complex motifs which are applied or affixed to the transfer film 1C, which could not be achieved using uniform film and a simple hot or cold transfer pressing system, and include motifs of the hologram or magnetic marker type such as the motifs 24A (fig. 3) in addition to motifs applied by a simple transfer such as motifs of type 21A.

All other features of the system (fig. 7) being the same, the position of the motif 14C on the film 1C upstream of the transfer station 4C must be detected. It is detected by the detector 72C, which supplies a signal S1 to the control system 7C; the latter controls the motor 351C of cylinder 35C in the group of intake cylinders 35C, 36C, issuing a command to feed the film 1C forward step by step, and, when the motif 24C is on a level with the transfer element 411C, 412C of the transfer cylinder 41C, move it in synchronisation with the strip 2C for the time

needed to make the transfer.

The speed differences between unreeling from the roll supplying film 31C (supply reel) and the film 1C consumed in the transfer station are absorbed in the sliding system 9C comprising two stationary cylinders 91C, 92C and a cylinder 93C loaded with a weight and applying a constant tension to the film 1C.

The system managed by the control system 7C receives the detection signals S1, S2 from the detectors 71C, 72C detecting the markers 14C, 24C carried by the film 1C and the receiving strip 2C.

Figure 8 illustrates a receiving strip 2D on which images 25D and markers 23D have been printed. The transfer applied to this strip has coded motifs 24D, for example holograms.

Figure 9 illustrates a receiving strip 2E provided with a printed image 25E and markers 23E as well as motifs 24E, such as electromagnetic detection markers, as an anti-theft security feature.

In figures 8 and 9, the strips 2D, 2E are wound once the coded motifs 24D and electromagnetic motifs 24E have been transferred; they will be cut later, in a packaging installation, for example.

Since the motifs 24D, 24E may be slightly thicker by a certain degree on winding, it may be practical to transfer them onto the strip 2D, 2E at successive positions that will not be aligned when the strip is in the wound state, offsetting them transversely (relative to the axis of the winding reel), which can be done using a transfer cylinder such at that illustrated in figure 10.

This transfer cylinder 41F is mounted with transfer elements 411F, 412F distributed around two peripheral rings inside which the elements 411F, 412F are transversely offset. These rings may be ellipses, for example (a plane intersecting the cylinder 41F). In the example illustrated in figure 10, the transfer elements 411F, 412F of each unit are very close together.

The transfer elements 411F and 412F may contain extremely varied designs depending on the graphics to be transferred and the type of zone to be produced; for example a preferred format is that of making an antenna (24E), the effect of which will be optimised by amplifiers, or transferring printed circuits (24D).

In certain applications, the receiving strip 2D and 2E will therefore have motifs constituting a coating applied from the transfer film (1) and:

- graphics with a variety of colours, which may or may not be metallic, polychromatic motifs, holograms in which the graphic element is positioned relative to the transfer element (411 and 412) and the pre-printed strip (2),
- zones intended to permit binary recordings and/or to form an antenna of various shapes and dimensions incorporating amplifiers for example, in order to optimise the effect of a magneto-restrictive coating with a thickness of 25 to 900 Angström, designed to resonate in an alternating electromagnetic field generated at a selected frequency between 73 and 530 Hz and which will cause no resonance when deactivated,
- finally, and/or form printed circuits having insulating and conductive layers, one or more chips in order to transfer onto a strip 2D an antenna capable of recording, calculating and emitting in order to provide an intelligent marker.

The transfer strip (F), designed as a means of making antennas with an anti-theft feature, is advantageously made from a metallic layer (C4) of a metal mixture or an alloy with a base of cobalt, iron and boron or any other compound having magneto-restrictive properties, by metallizing under vacuum a polyester film (C1) coated with one or more dividing layers (C2), then covered with an adhesive (C5).

CLAIMS

1) System of transfer printing, in particular gilding, a motif lifted from a transfer film by a die, which is to be affixed on a receiving strip to form a product,

- the transfer film and the receiving strip being synchronised at the transfer station at the instant of transfer,

characterised in that

it comprises

- a means for driving (3) the transfer film (1),
- a means for driving (5) the receiving strip (2),
- a transfer station (4),
- a control means (7) controlling the drive means, whereby the drive means (3, 31, 32) of the film (1) feeds the film (1) forward by a step (L1) corresponding to the motif to be transferred and the drive means (5) of the receiving strip (2) feeds said strip (2) forward by the step (L2) of the product (22, 23) in readiness for each transfer, and the transfer means (41, 42) of the transfer station (4).

2) System as claimed in claim 1,

characterised in that

the transfer element (41) at the transfer station (4) is activated by a jack (42), the control means (7) immobilising the film (1) and the strip (2) during the time the transfer is being operated.

3) System as claimed in claim 1,

characterised in that

the transfer means (4A) comprises at least one transfer element (411A, 412A) mounted on a rotary element (41A) and the means for driving (3A) the film (1A) and that of the receiving strip (2A) are controlled (7A) so as to drive the film (1A) and the receiving strip (2A) at the same speed as the peripheral speed of the transfer element (41A) during the time the transfer is being operated.

4) System as claimed in claim 1,
characterised by
a first detector (71, 71A) assigned to the strip (2, 2A) to detect the step (L2) of the product and supply a signal (S) to the control means (7A) managing the forward movement of the strip (2A); and
the strip (2, 2A) has pre-printed markers (23, 23A) designed to be read by the detection means (71, 71A).

5) System as claimed in claim 1,
characterised in that
it has a second detector (72C) assigned to the film (1C) to detect the motif (14C) of the film (1C) and supply a signal (S2) to the control means (7C) managing the drive means of the film (1C).

6) System as claimed in claim 1,
characterised in that
the means for driving the film (1) and the means for driving the receiving strip (2) both operate step by step or one is operated step by step and the other continuously or both are operated continuously.

7) System as claimed in claim 1,
characterised by
several means, disposed in parallel, for driving films (1B, 1'B) so that several motifs can be transferred to the receiving strip (2B) simultaneously.

8) System as claimed in claim 1,
characterised in that
the transfer element (41F) is a cylinder, which prints the successive motifs with an offset in order to reduce overlapping thicknesses when the strip is reeled or the sheets cut from the strip are stacked after the transfer.

9) System as claimed in claim 8,
characterised in that
the transfer elements (411E, 412E) of the transfer cylinder (41F) are distributed around a cylinder with a circular section in an offset arrangement following a line corresponding to the intersection of the cylinder by an inclined plane (ellipse).

10) System as claimed in claim 8,
characterised in that
the transfer elements (411F) and (412F) are designed to apply to the strip (2A) polychromatic motifs with or without metal, holographic motifs and zones intended to permit binary recordings, the material for this purpose being lifted from the transfer strip (1) or (1A).

11) System as claimed in claim 9,
characterised in that
the transfer elements (411F) and (412F) are designed to apply to the strip (2E) an antenna of various shapes and dimensions incorporating amplifiers for example, in order to optimise the effect of a magneto-strictive coating with a thickness of 25 to 900 Angström, designed to resonate in an alternating electromagnetic field generated at a selected frequency between 73 and 530 Hz and which will cause no resonance when deactivated,

12) System as claimed in claim 9,
characterised in that
the transfer elements (411E) and 412E) are designed to enable the transfer of various shapes and dimensions of printed circuits having insulating and conductive layers, one or more chips in order to transfer onto a strip (2D) an antenna capable of recording, calculating and emitting in order to provide an intelligent marker.

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(71) Déposant *(pour tous les États désignés sauf US)*: **BREGER EMBALLAGES S.A.** [FR/FR]; 9, rue Pasquier, F-75008 Paris (FR).

(72) Inventeurs; et
(75) Inventeurs/Déposants *(pour US seulement)*: **BREGER, Guy, Marcel, Charles, Claude** [FR/FR]; 10, chemin des Violettes, F-89100 Rosoy-Sens (FR). **BREGER, Alain, Charles, Marcel, Jacques** [FR/FR]; 13, rue de la Balestière, F-89100 Saint-Clement (FR).

(74) Mandataire: **CABINET HERRBURGER**; 115, boulevard Haussmann, F-75008 Paris (FR).

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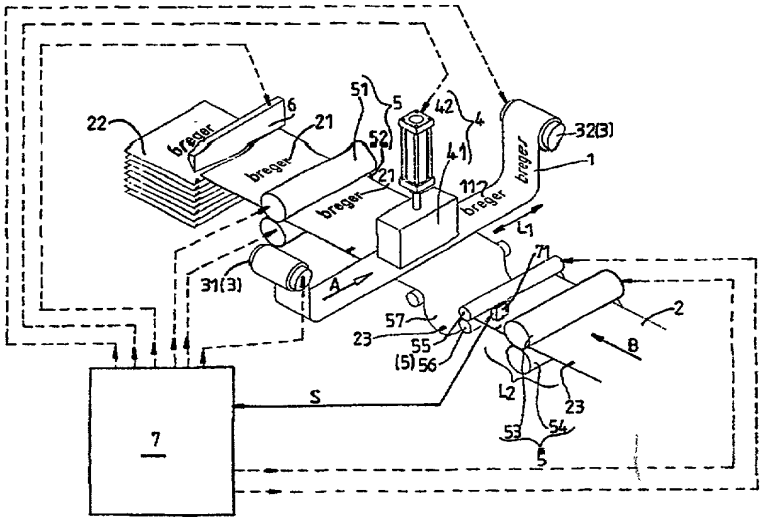
[Suite sur la page suivante]

(54) Title: TRANSFER PRINTING INSTALLATION, IN PARTICULAR BY GILDING

(54) Titre: INSTALLATION D'IMPRESSION PAR TRANSFERT, NOTAMMENT PAR DORURE



(57) Abstract: The invention concerns a transfer printing installation, in particular by gold tooling, of a pattern taken from a transfer film by a matrix to be affixed on a receiving strip and form a product, the transfer film and the receiving strip being in synchronisation at the time of transfer at the site of transfer. The invention is characterised in that it comprises: means driving (3) the transfer film (1); means driving (5) the receiving strip (2); a transfer station (4); control means (7) controlling the driving means such that for each transfer, the means driving (3, 31, 32) driving the film (1) moves forward the film (1) by the step (L1) of the pattern to be transferred, the means driving (5) the receiving strip (2) moves forward said strip (2) by a step (L2) of the product (22, 23) and the transfer means (41, 42) of the transfer station (4).

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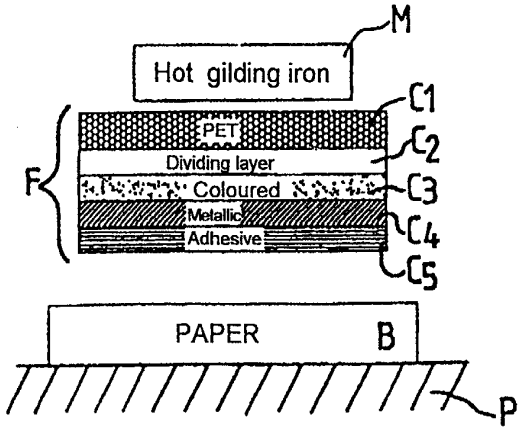


FIG.1A

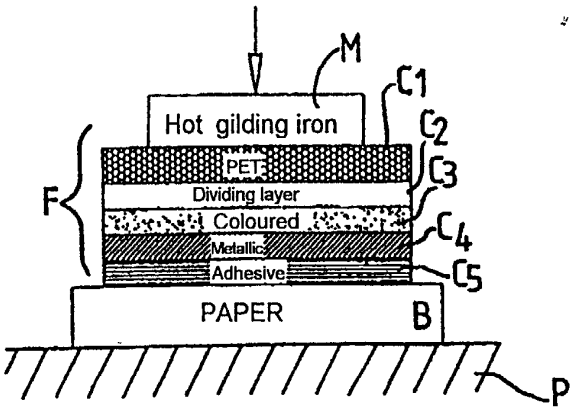


FIG.1B

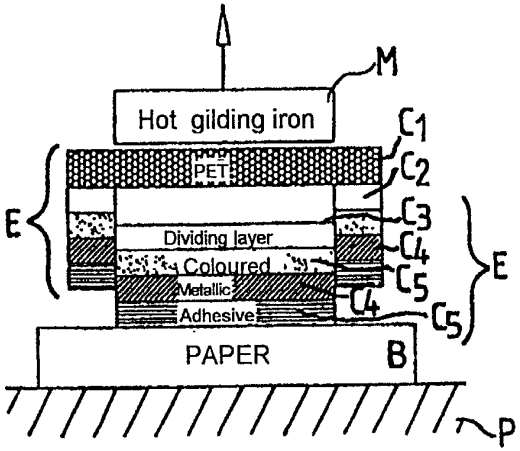
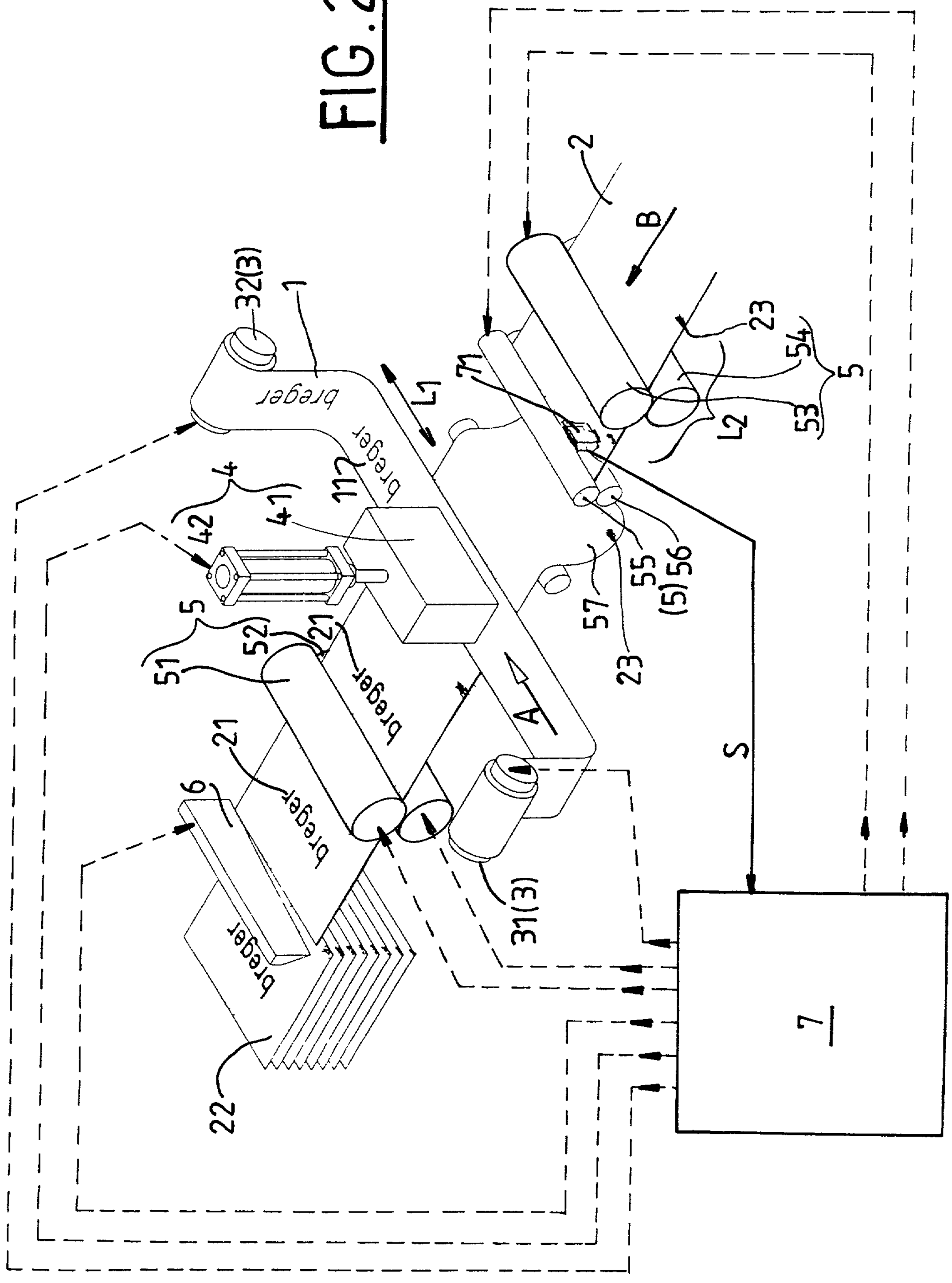


FIG.1C

FIG.2



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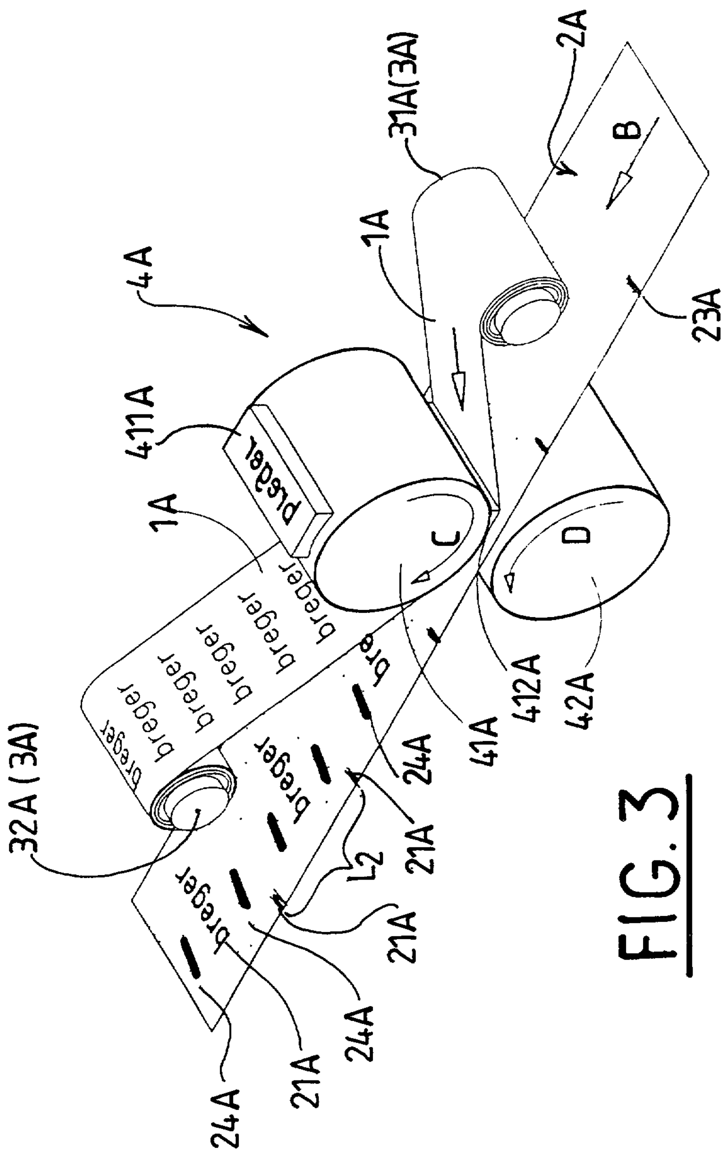


FIG. 3

FIG.4

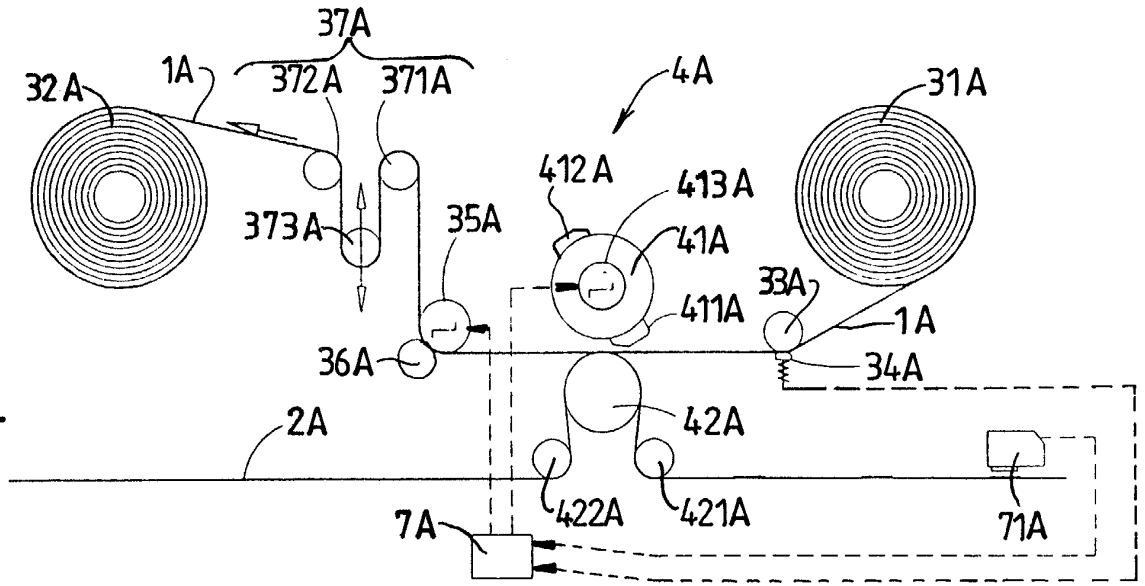
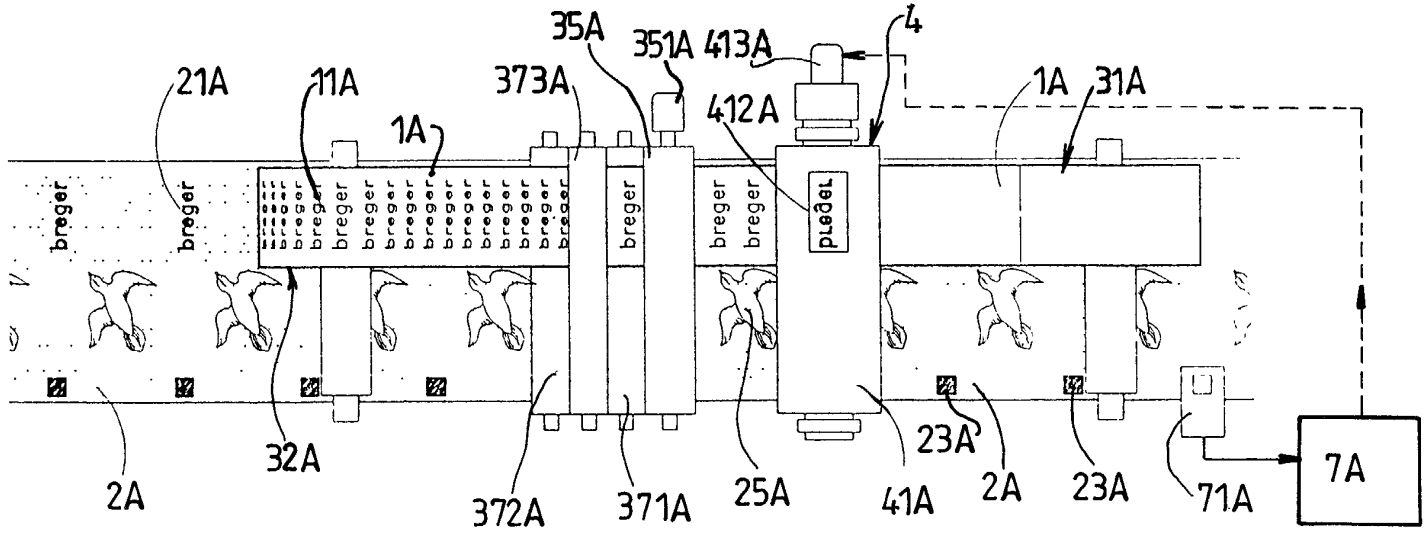


FIG.5



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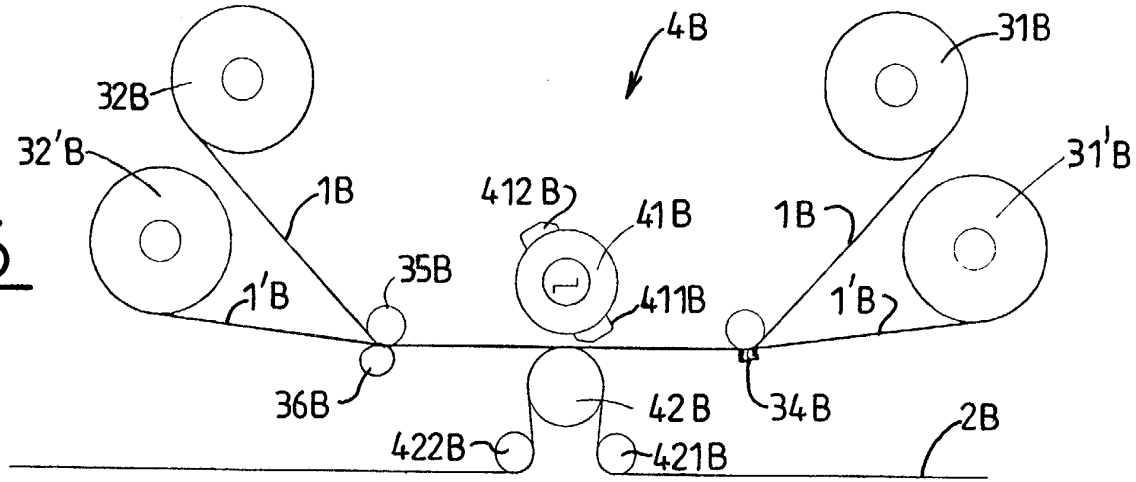

FIG.6

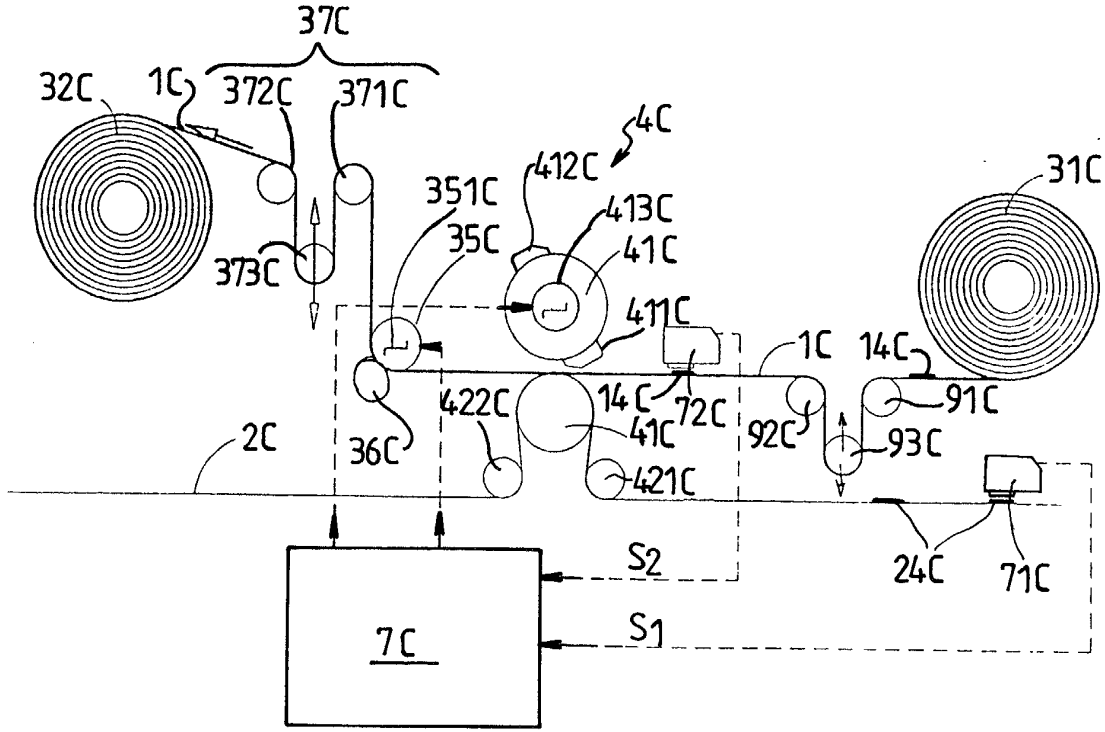

FIG.7

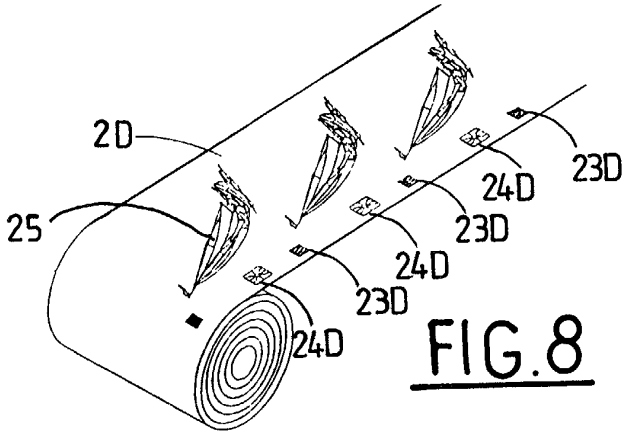

FIG.8

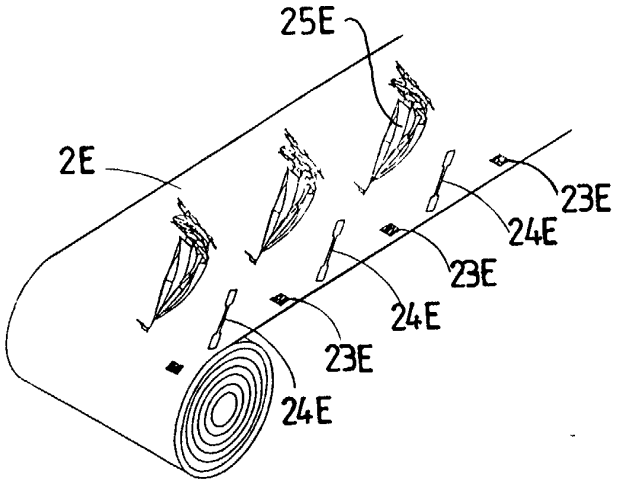

FIG.9

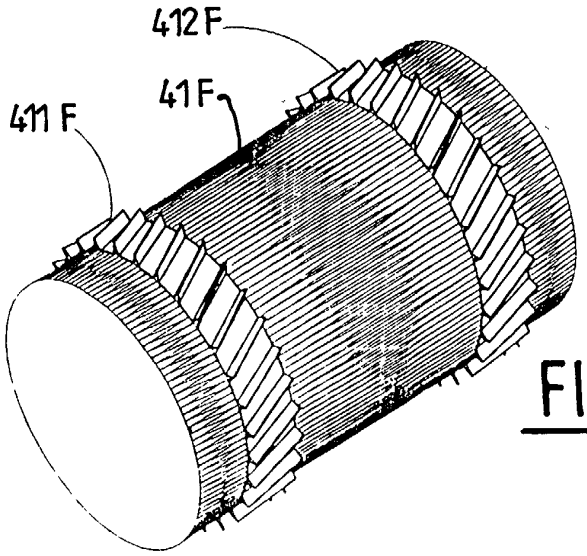

FIG.10

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#4

PATENT
Attorney Docket No. 144-220

DECLARATION AND POWER OF ATTORNEY

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are stated below next to my name:

I believe I am the original, first, and sole inventor (if only one name is listed below) or an original, first, and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

TRANSFER PRINTING INSTALLATION, IN PARTICULAR BY GILDING

the specification of which is attached hereto unless the following box is checked

☒ was filed on September 7, 1999 as Application No. _____ or PCT Application No. PCT/FR99/02119 and amended on March 7, 2002 (if applicable).

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to the patentability of this application in accordance with 37 CFR §1.56.

I hereby claim foreign priority benefits under 35 U.S.C. §119(a)-(d) or §365(b) of any foreign application(s) for patent or inventor's certificate, or §365(a) of any PCT international application which designated at least one country other than the United States, listed below and have also identified below any foreign application for patent or inventor's certificate or PCT International application having a filing date before that of the application on which priority is claimed:

PRIOR FOREIGN/PCT APPLICATION(S)

COUNTRY/OFFICE	APPLICATION NO.	DATE OF FILING	PRIORITY CLAIMED
			☐YES NO ☐
			☐YES NO ☐
			☐YES NO ☐

I hereby claim the benefit under 35 U.S.C. §119(e) of any United States provisional application(s) listed below.

PROVISIONAL APPLICATION NUMBER	DATE OF FILING

I hereby claim the benefit under 35 U.S.C. §120 of any United States application(s) or §365(c) of any PCT International application(s) designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of 35 U.S.C. §112, I acknowledge the duty to disclose material information as defined in 37 CFR §1.56 which became available between the filing date of the prior application and the national or PCT international filing date of this application:

PRIOR U.S. APPLICATIONS OR PCT INTERNATIONAL APPLICATIONS DESIGNATING THE U.S. FOR BENEFIT UNDER 25 U.S.C. §120

		Status (check one)		
Application Serial No.	**Date of Filing**	**Patented**	**Pending**	**Abandoned**
		☐	☐	☐

And I hereby appoint Arthur H. Seidel, Registration No. 15,979; Gregory J. Lavorgna, Registration No. 30,469; Daniel A. Monaco, Registration No. 30,480; Thomas J. Durling, Registration No. 31,349; John J. Marshall, Registration No. 29,671; Joseph R. Delmaster, Jr., Registration No. 38,399, Robert E. Cannuscio, Registration No. 36,469, and George A. Frank, Registration No. 27,636, my attorneys or agents with full power of substitution and revocation, to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith. Customer No. 23973

Address all correspondence to **Robert E. Cannuscio**, Drinker Biddle & Reath LLP, One Logan Square, 18th & Cherry Streets, Philadelphia, PA 19103-6996. Address all telephone calls to **Robert E. Cannuscio**, (215) 988-3303 (telefax: (215) 988-2757).

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

FULL NAME OF SOLE OR FIRST INVENTOR

GUY	MARCEL, CHARLES, CLAUDE	BREGER
(GIVEN NAME)	*(MIDDLE INITIAL OR NAME)*	*(FAMILY OR LAST NAME)*

Inventor's signature: Guy BREGER

Date: April 5, 2002

Country of Citizenship: France

Residence: Rosoy-Sens FRx France
(City) *(State or Foreign Country)*

Post Office Address: 10, chemin des Violettes
F-89100 Rosoy-Sens France

FULL NAME OF SOLE OR SECOND INVENTOR

ALAIN	CHARLES, MARCEL, JACQUES	BREGER
(GIVEN NAME)	*(MIDDLE INITIAL OR NAME)*	*(FAMILY OR LAST NAME)*

Inventor's signature: ALAIN BREGER.

Date: April 5, 2002

Country of Citizenship: France

Residence: Saint-Clement FRx France
(City) *(State or Foreign Country)*

Post Office Address: 13 rue de la Balestière
F-89100 Saint-Clement France